












Date: Thursday, 19/03/2009 4:30:35 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 46607	
Estimate Number : 10310	
P.O. Number :	Part Number : D26175
This Issue : 19/03/2009 S.O. No. :	Drawing Number : D2617 REV D2
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D2
Previous Run : 45663	Material :
Written By :	Due Date : 23/03/2009 Qty: 100 Um: Each
Checked & Approved By : <u>JLD 09.03.19</u>	
Comment : Est H 04.07.14 Reformat; added step 5 KJ/JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M6061T6T0500W058 6061-T6 RD Tube .500 x.058W
	 
<p>Comment: Qty.: 0.0205 f(s)/Unit Total: 2.0475 f(s)</p> <p>6061-T6 Round Bar 1.5"</p> <p>Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)</p> <p>Ø0.500" tubing x 0.058" wall</p> <p>M6061T6T0.500W.058)</p> <p>Batch <u>1110335</u> <u>09/03/21</u> <u>100 pcs</u></p>	
2.0	HARDINGE HARDINGE CNC LATHE SMALL
	 
<p>Comment: HARDINGE CNC LATHE SMALL</p> <p>1-Machine as per Folio FA438 and Dwg D2617</p> <p>2-Deburr <u>09/03/21</u> <u>100 pcs</u></p>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	 
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>09/03/21</u> <u>100 pcs</u></p>	
4.0	QC8 SECOND CHECK
	 
<p>Comment: SECOND CHECK <u>J.F. 09/03/23</u> <u>100</u></p>	
5.0	HAND FINISHING1 HAND FINISHING RESOURCE #1
	 
<p>Comment: HAND FINISHING RESOURCE #1</p> <p>Acid etch and Alodine as per QSI 005 4.1 <u>09-03-23</u> <u>X100</u></p>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BUSHING

Job Number: 46607

Part Number: D26175

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



100

Comment: INSPECT ALODINE

BF 04-03-23

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST39

AS 09/03/24 (100)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-03-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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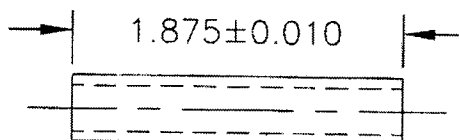
NOTE: Date & initial all entries



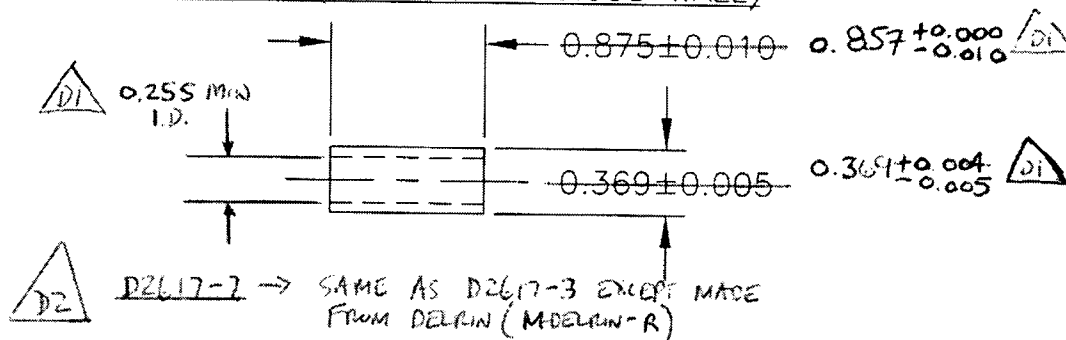
DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2617	REV. 0 SHEET 1 OF 1
DATE 01.07.04				TITLE BUSHING SCALE 1:1	
A 96.10.08 NEW ISSUE					
B 97.05.08 .875 WAS 1.125					
C 97.06.04 0.369 DIA WAS 0.375					
D 01.07.04 ADD MAT'L SPEC AND TOL./DIM. NOTE					
D1 CP 04.07.12 CORRECT TOLERANCE (NCR 779)					

DL 04.04.10 #CP ADD D2617-7

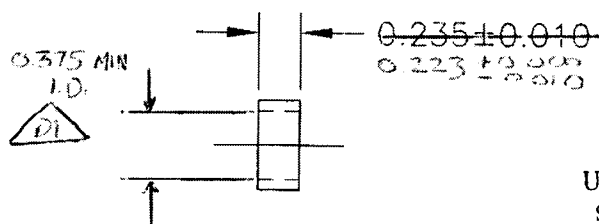
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05 #CP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46607

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4) OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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